

Work Order ID 62364

Tuesday, September 28, 2010 11:51:04 AM



Page 1

Item ID: PB67-43001-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Adjustable Blade Support Assembly

Start Date: 9/29/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *10-9-28*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

B67-43001-13

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding □ 2- assemble parts and weld as per dwg

10-10-05 *1* *φ*

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

N/A

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Small Fab

Small Fab

Small Fab

Memo

1- grind weld flush in area of PB67-43001-249 only □2- install helicol insert as per dwg

QC 9

10.10.05

1

1

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

10.10.06

10.10.05

71

150



Hand Finish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

10.10.06

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Required Date: 10/6/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

BR 10-10-6

M 18144

Memo

0.00

1- MASK TUBE FROM BASE TO GUSSET START TIME:

140 OVEN TEMPERATURE: 320 FINISH
TIME: 2:10

0.

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> M 10/10/11

Memo

0.00

1 /

180



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1- match drill cover to existing holes in support 2- assemble as per dwg

10-10-14

1 /

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				10			
200 Packaging Packaging	Identify as per dwg & Stock Location: <u>W/H</u> Memo	0.00 0.00				1	1		
210 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/10/14 MF 10-10-14

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Picklist Print

Tuesday, September 28, 2010 11:51:04 AM

Page 1

Work Order ID: 62364

Parent Item: PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly





Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec IPP RevC
10.09.27 per RevC EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 PB67-43001-249 Inner Tube Bushing		Manufactured	No			100	Each	11.0000	1	1		10.10.04	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST438				11					
				52480				11					
 PB67-43001-253 Gusset		Manufactured	No			100	Each	4.0000	1	1		10.10.04	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST438				4					
				44983				4					
 PB67-43001-254 Gusset		Manufactured	No			100	Each	24.0000	1	1		10.10.04	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST438				24					
				52481				24					
 PB67-43001-255 Inner Tube		Manufactured	No			100	Each	2.0000	1	1		10.10.04	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST446				2					
				43071				2					

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Tuesday, September 28, 2010 11:51:04 AM

Page 2

Work Order ID: 62364

Parent Item: PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-67 Manufactured No

130

Each

2.0000

1

1

PB67-43001-67

Location

Loc Qty

Loc Code

ST446

2

52634

2

MS124780

Purchased

No

180

Each

142.0000

1

1

HELICAL INSERT

Location

Loc Qty

Loc Code

ST314

142

111064

142

MS27039-1-10

Purchased

No

180

Each

117.0000

8

8

Screw

Location

Loc Qty

Loc Code

ST291

117

112794

17

112940

100

NAS1149D0316J

Purchased

No

180

Each

0.0000

8

8

Washer

AN96JD10LL

Tuesday, September 28, 2010 11:51:04 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

180

Each

2,907.000

8

8



Washer



1115622 10.10.14

Location

Loc Qty

Loc Code

ST298

2907

114292

114

114884

41

115107

27

115622

2716

9221

9

PB67-43001-69

Manufactured

No

180

Each

5.0000

1

1



90 Degree Cover Plate



10.10.14

Location

Loc Qty

Loc Code

ST444

5

52433

5

PB67-43001-83

Manufactured

No

180

Each

6.0000

1

1



PB67-43001-83



10.10.14

Location

Loc Qty

Loc Code

ST445

6

52418

6

1

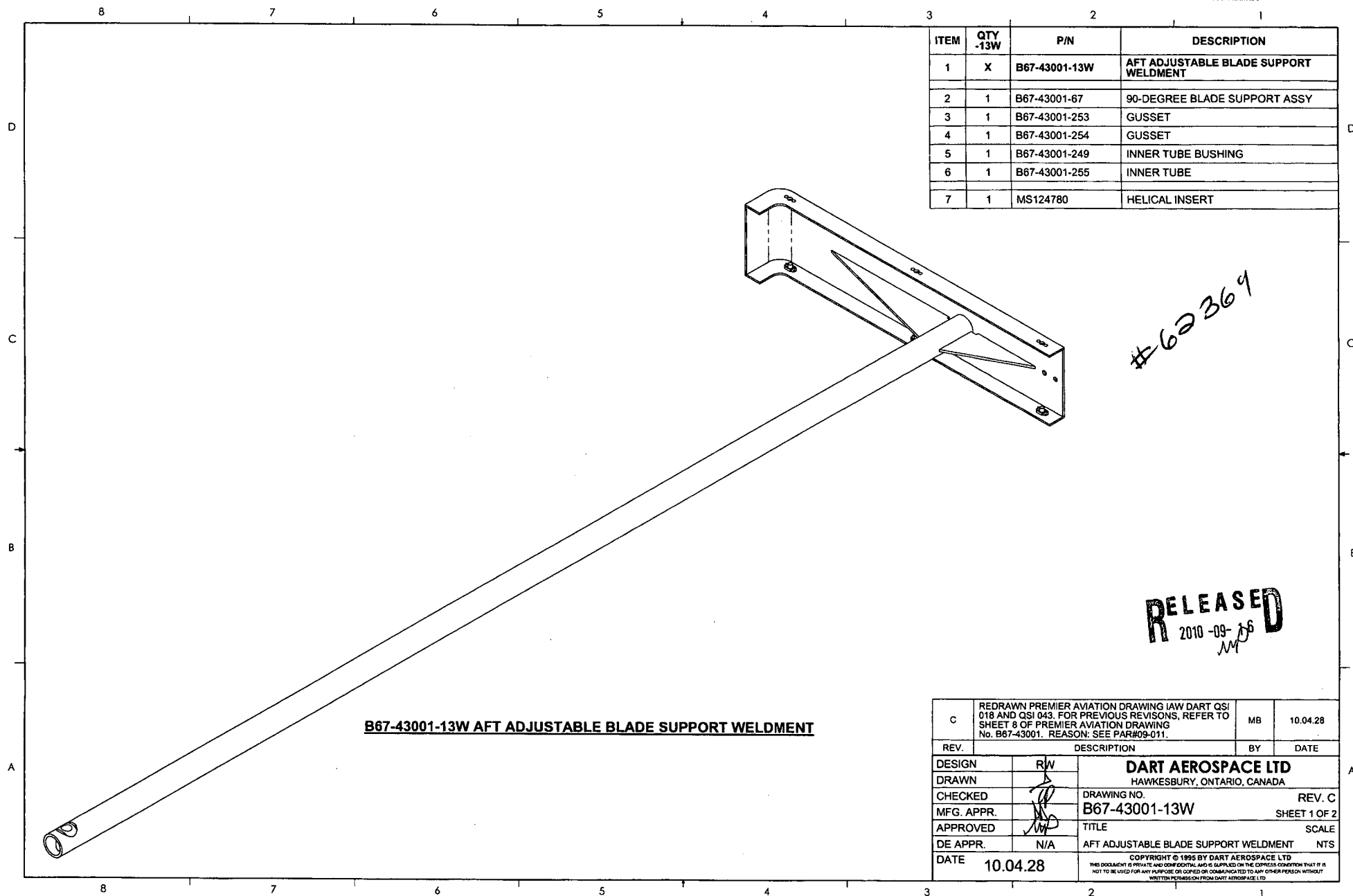
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NOTE: Date & initial all entries



B67-43001-13W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

ITEM	QTY -13W	P/N	DESCRIPTION
1	X	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-253	GUSSET
4	1	B67-43001-254	GUSSET
5	1	B67-43001-249	INNER TUBE BUSHING
6	1	B67-43001-255	INNER TUBE
7	1	MS124780	HELICAL INSERT

#62369

RELEASED
2010-09-18

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-13W REV. C TITLE AFT ADJUSTABLE BLADE SUPPORT WELDMENT SCALE NTS		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED		SHEET 1 OF 2		
DE APPR.	N/A			
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

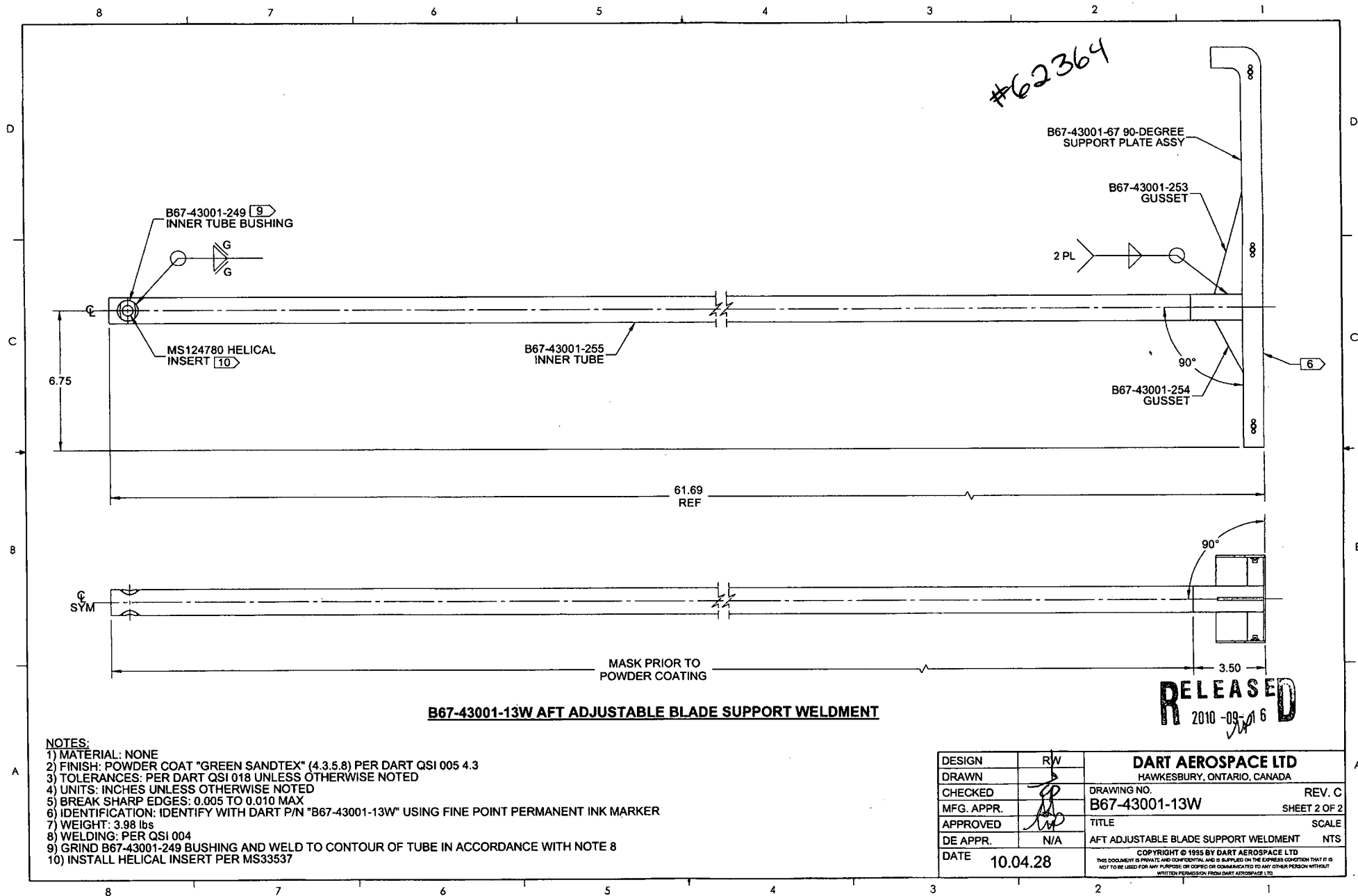
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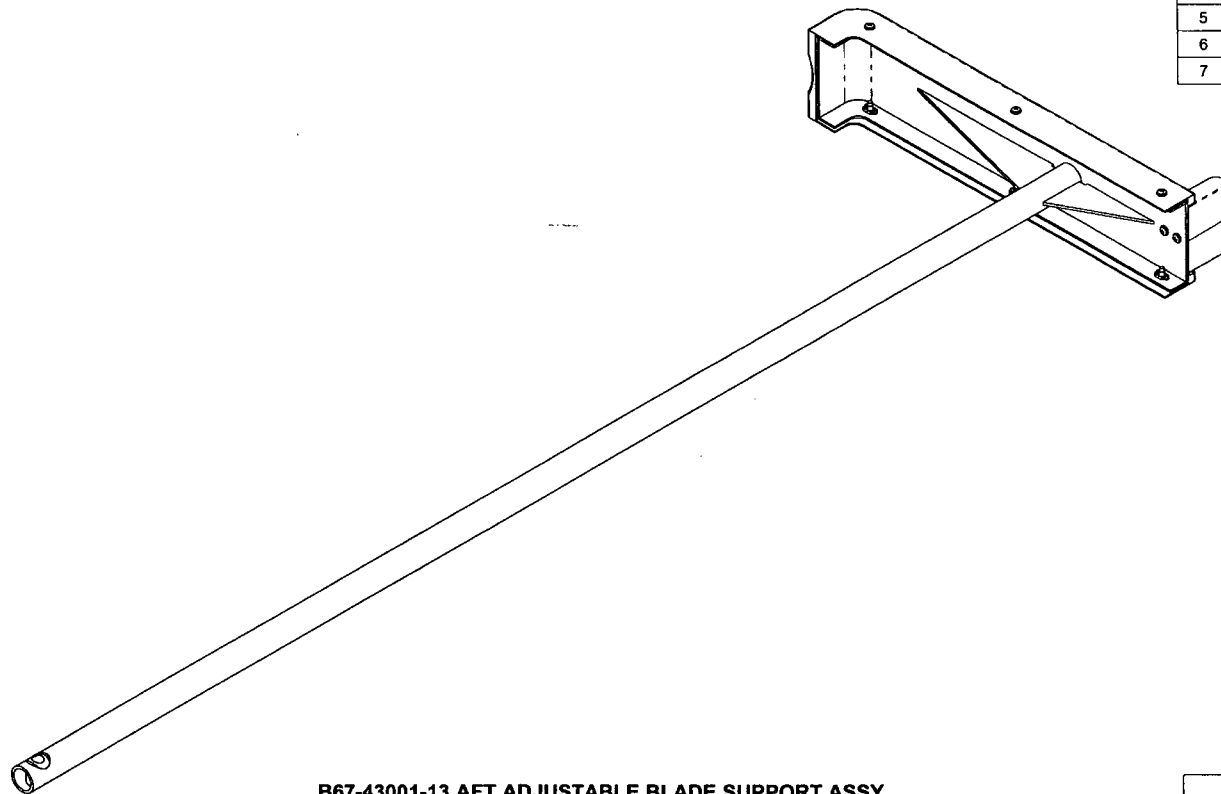
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B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -13	P/N	DESCRIPTION
1	X	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

RELEASED
2010-09-16
JW

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	h			
CHECKED	JW	DRAWING NO.	REV. C	
MFG. APPR.	JW	B67-43001-13	SHEET 1 OF 2	
APPROVED	JW	TITLE	SCALE	
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS	
DATE	10.04.28	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

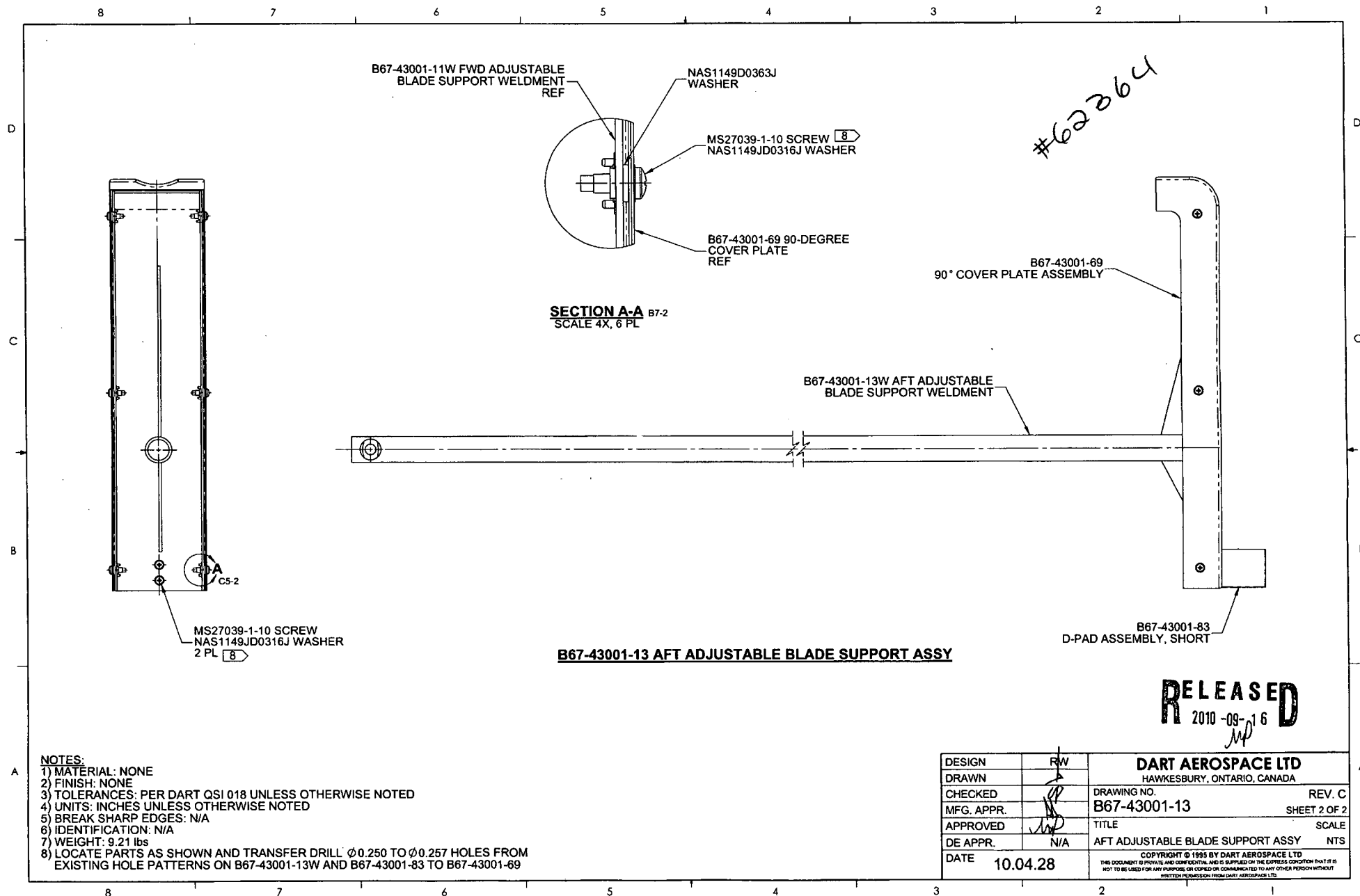
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